

Date: Monday, 29/09/2008 11:56:20 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARSHOE
Job Number :	42328		
Estimate Number :	12729		
P.O. Number :		Part Number :	D353539
This Issue :	29/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3535 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	37277	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/10/2008
Written By :		Qty:	12
Checked & Approved By :	JLD 28.9.29	Um:	Each
Comment :	Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.9986 sf(s)/Unit Total : 11.9826 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 109088 HB 8-10-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B HB 8-10-22
 Prog Rev: B



2-Deburr if necessary HB 8-10-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/10/22 (12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 Identify as D3535-41

S 08/10/22 (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 29/09/2008 11:56:20 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42328

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle on brake using Jig DT8158 as per Dwg D3535

08/10/22 (12)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/23 (X12)

7.0

POWDER COATING

POWDER COATING



M10642



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

11:10am

OVEN TEMPERATURE:

320°C

FINISH TIME:

11:40am

08-10-23

(X12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-10-23

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

08-10-23

(X12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/24

Job Completion



MF 08-10-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42328
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	X			
32.775	+/-0.010	32.775	X			
29.275	+/-0.010	29.275	X			
25.775	+/-0.010	25.775	X			
23.250	+/-0.010	23.250	X			
19.750	+/-0.010	19.750	X			
17.750	+/-0.010	17.750	X			
14.250	+/-0.010	14.250	X			
9.500	+/-0.010	9.500	X			
4.750	+/-0.010	4.750	X			
2.000	+/-0.010	2.000	X			
5.00	+/-0.030	5.00	X			
9.00	+/-0.030	9.00	X			
28.00	+/-0.030	28.00	X			
Ø0.188	+0.005/-0.001	.188	X			
1.885	+/-0.010	1.881	X			
0.300	+/-0.010	.306	X			
0.300	+/-0.010	.306	X			
0.038	+/-0.010	.040	X			

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>8-10-22</u>	Date: <u>08/10/22</u>	Date:	N/A

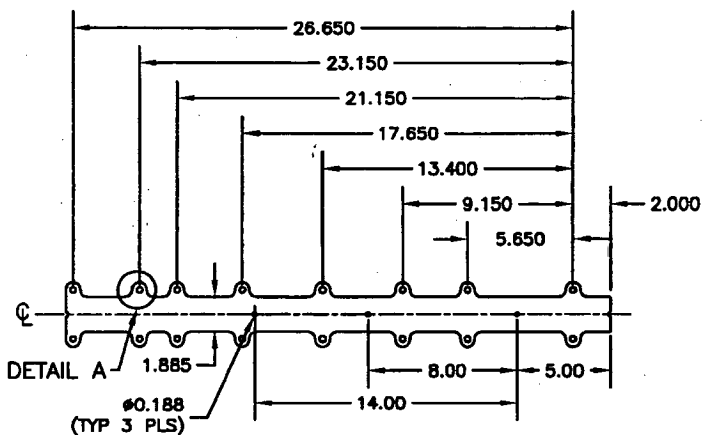
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM <u>AF</u>	<u>B</u>

DART

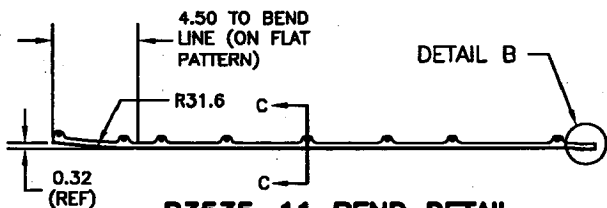
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07.04.17

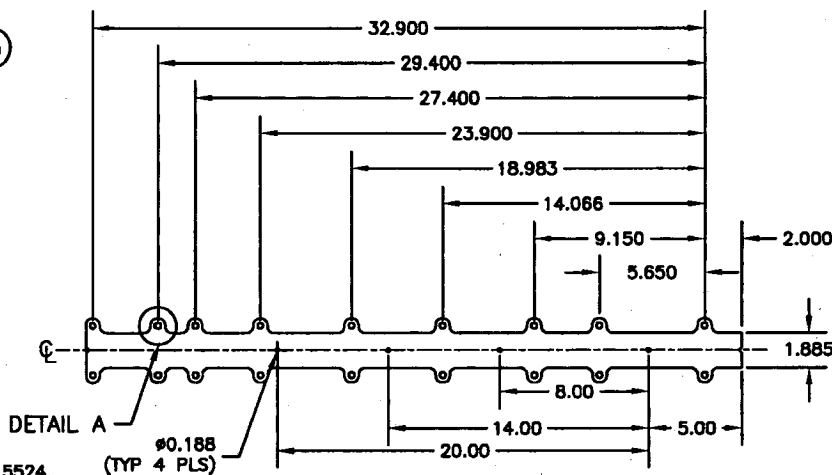
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CB	CH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
CH	CH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC



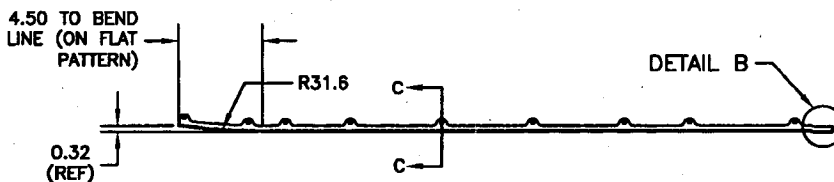
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

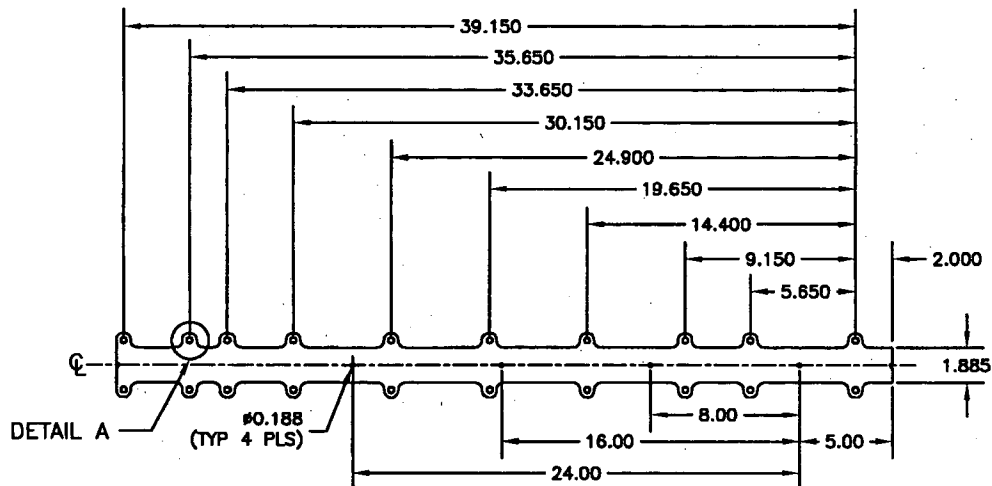
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WORK ORDER
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TITLE	WEARSHOE	SCALE	1:10	SHEET 2 OF 7



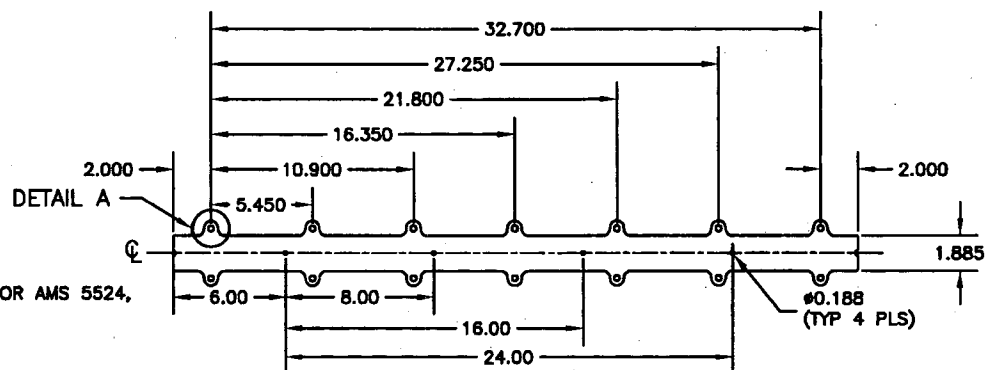
4.50 TO BEND
LINE (ON FLAT
PATTERN)

D3535-15F FLAT PATTERN

0.32
(REF)

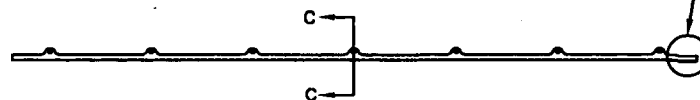
D3535-15 BEND DETAIL

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D3535-21F FLAT PATTERN

DETAIL B



D3535-21 BEND DETAIL

NOTES

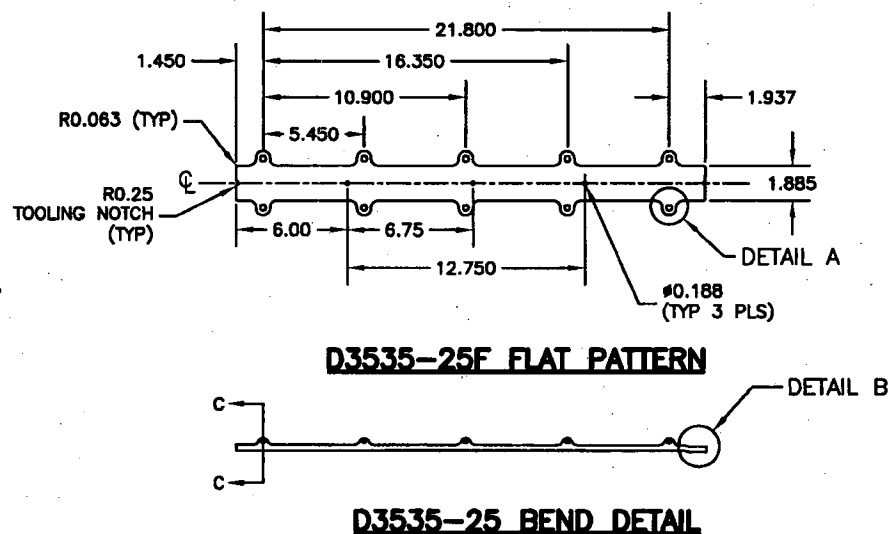
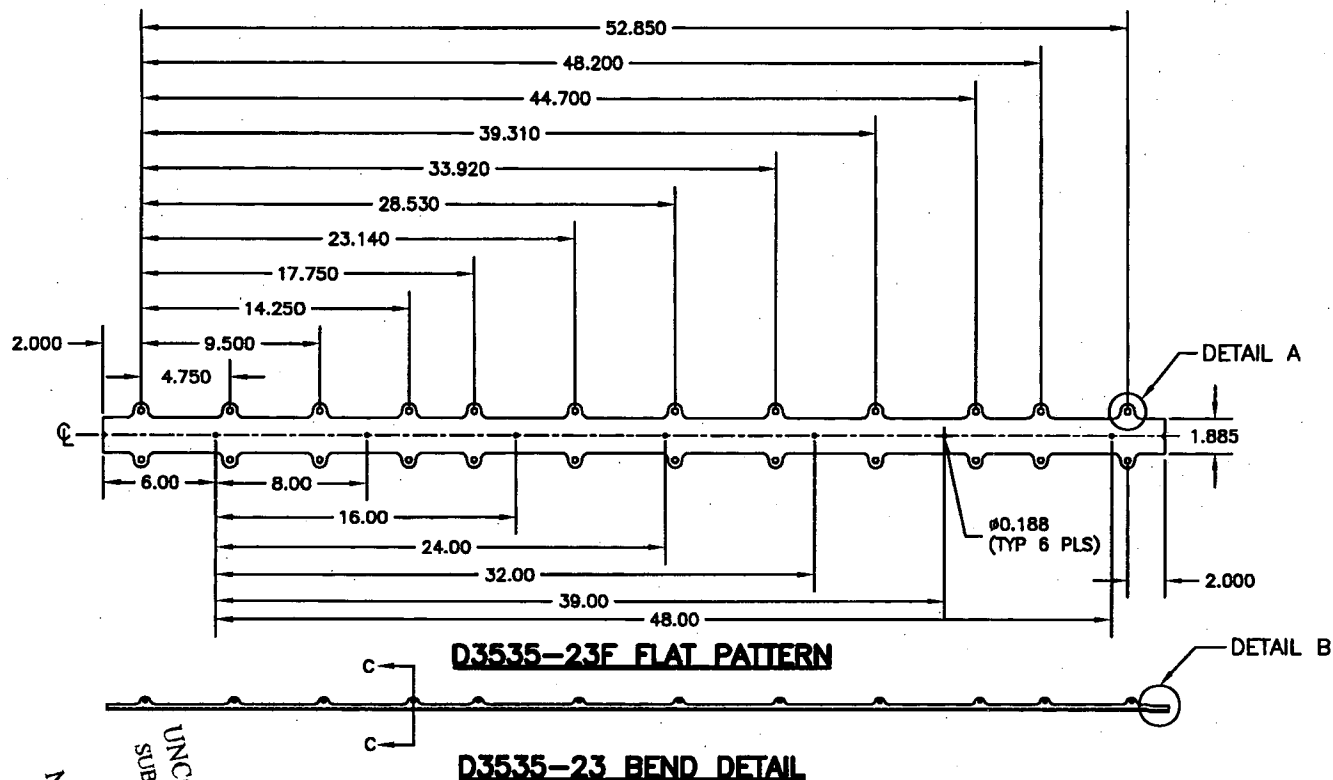
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

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<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE
		1:10

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**NOTES**

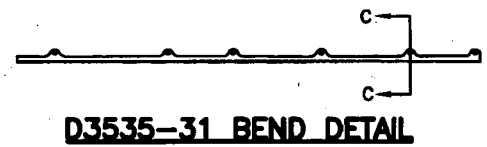
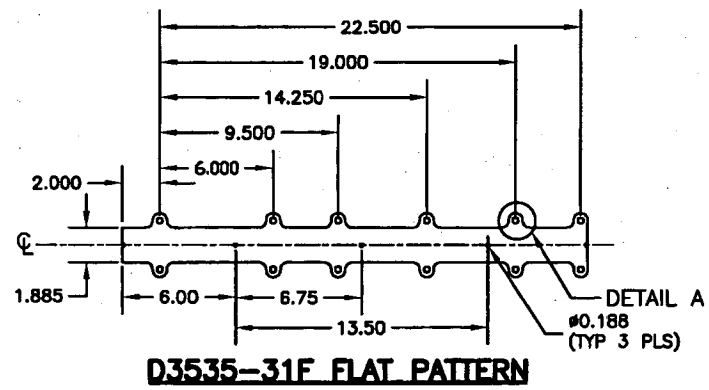
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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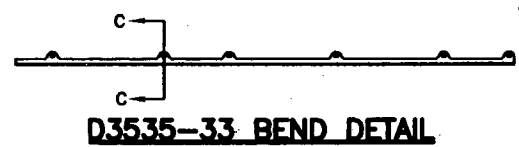
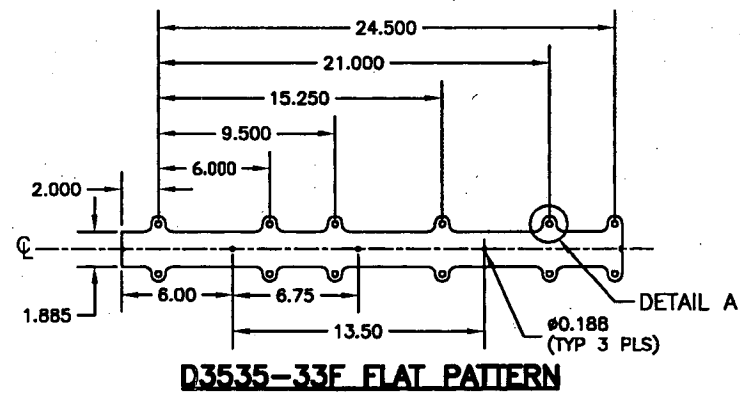
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
				SCALE
				1:10



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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT Q
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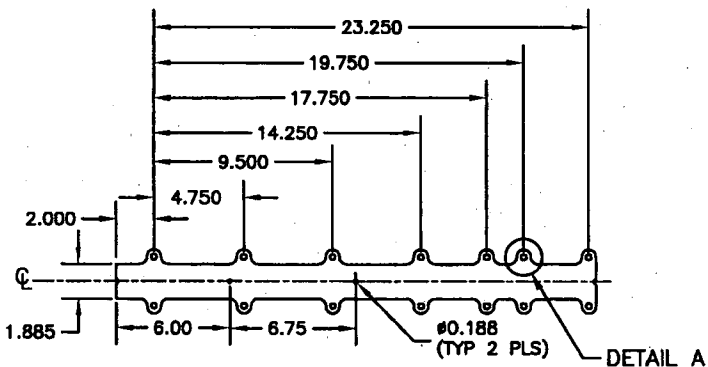


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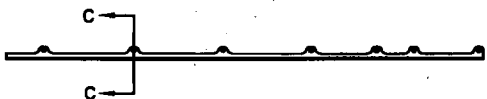
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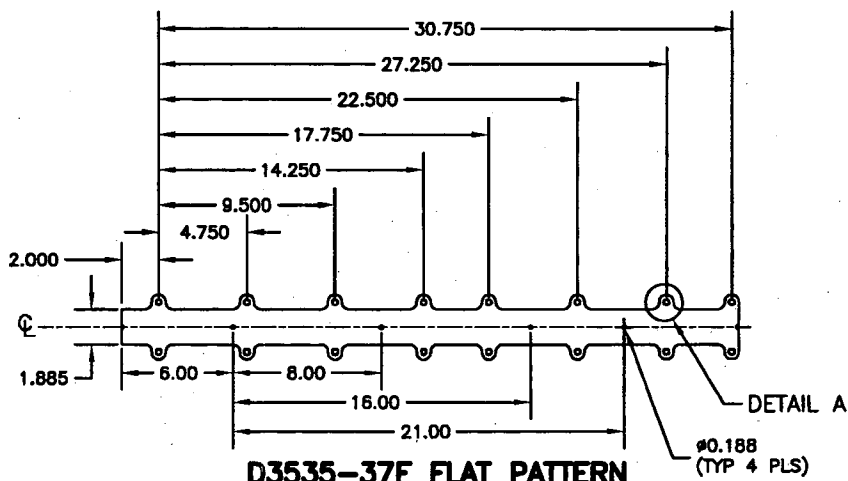
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		D3535	SHEET 5 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

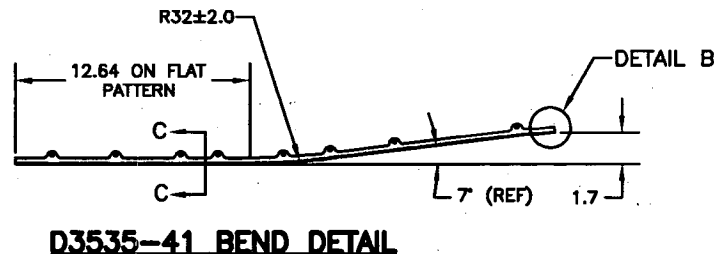
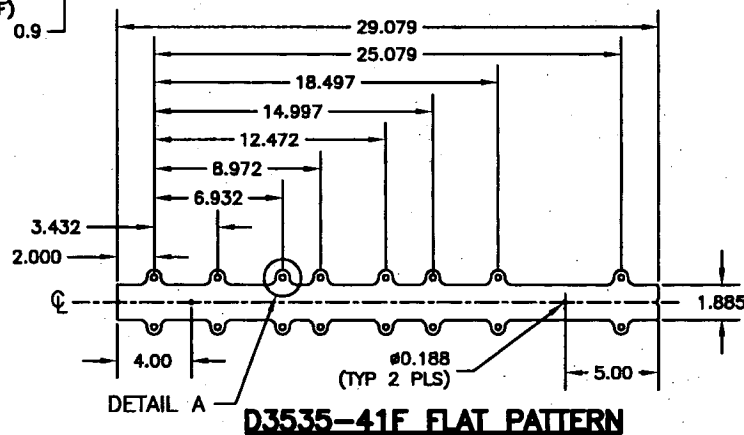
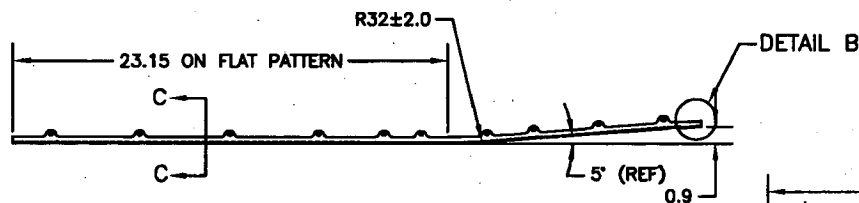
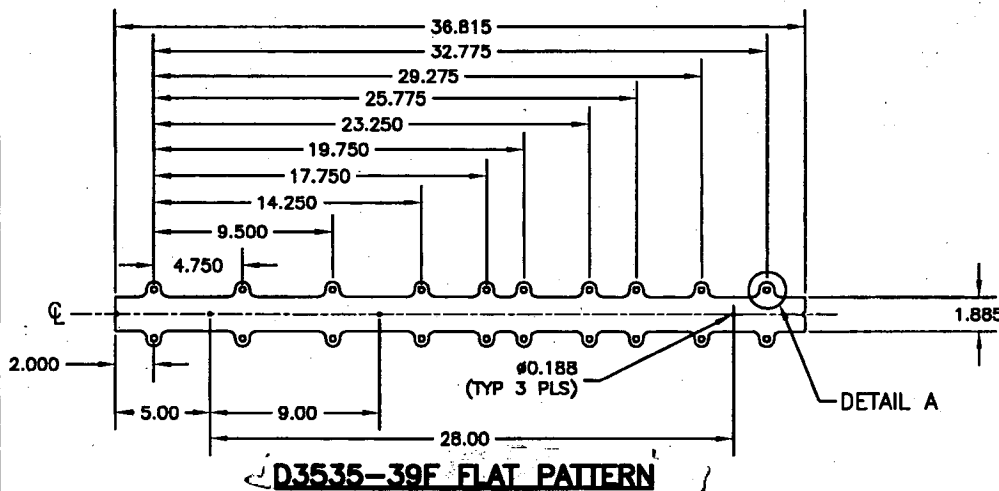
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	6 OF 7	SCALE
				1:10



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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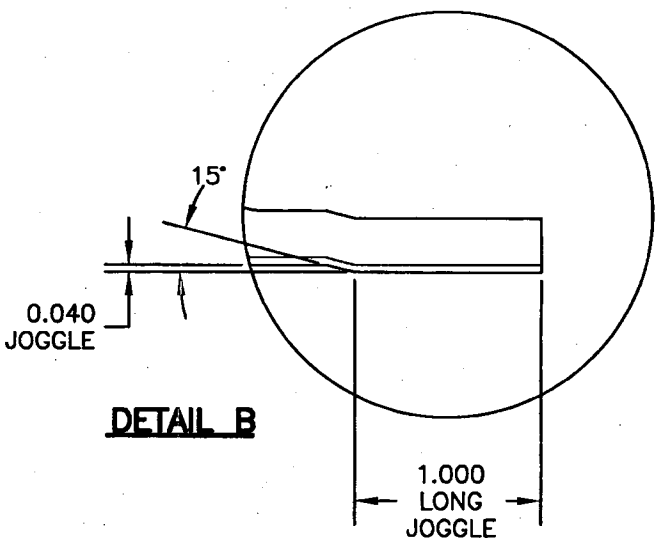
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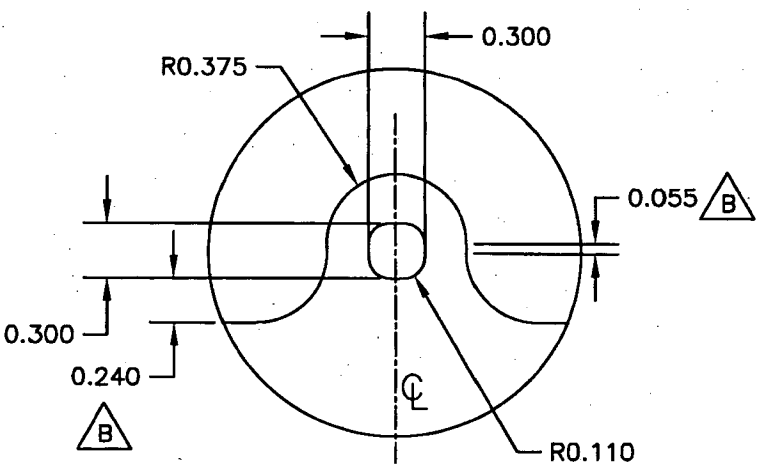
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
		SCALE	1:1	

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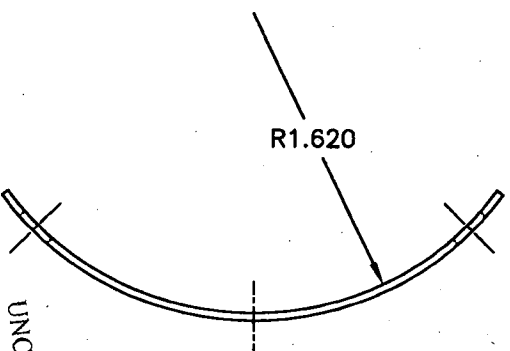
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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